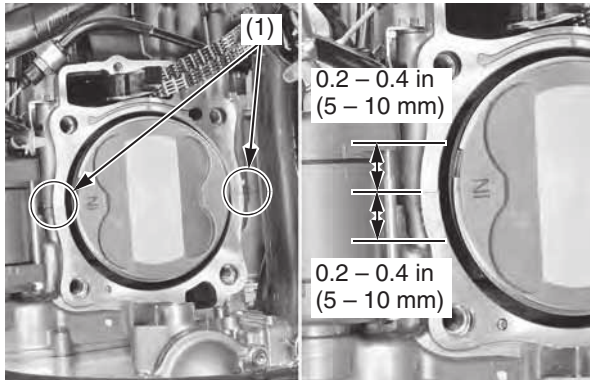


## Cylinder Installation

1. Clean the cylinder mating surfaces (1) of the crankcase, being careful not to let any material fall into the crankcase.
2. Remove the shop towels.
3. Apply liquid sealant (TB1141G manufactured by ThreeBond or equivalent) to the cylinder mating surface of the crankcase side as shown.

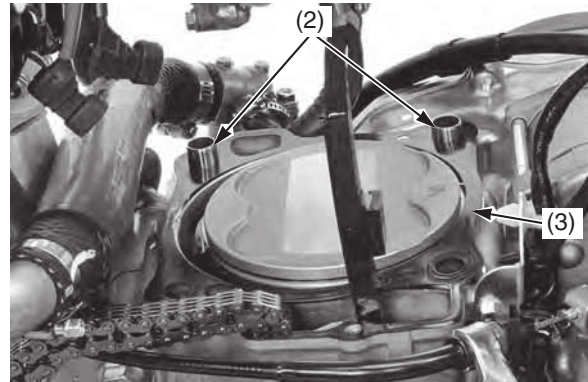


(1) cylinder mating surface

4. Install the dowel pins (2) and a new cylinder gasket (3).

### NOTICE

*Do not let the dowel pins fall into the crankcase.*



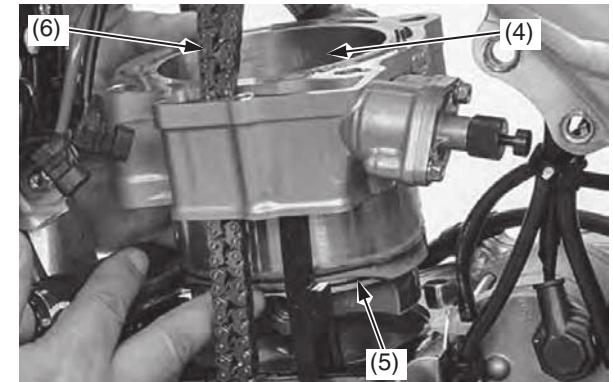
(2) dowel pins

(3) cylinder gasket (new)

5. Apply engine oil to the cylinder bore (4), piston outer surface and piston rings (5). Route the cam chain (6) through the cylinder. Install the cylinder over the piston rings by hand while compressing the piston rings.

### NOTICE

*Do not damage the piston rings and cylinder bore. Do not let the cam chain fall into the crankcase.*



(4) cylinder bore  
(5) piston rings

(6) cam chain